

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011622**Date Inspected:** 07-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chan Xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** TOWER COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Bay #10

This QA Inspector observed the following work in progress:

SMAW in the 2F position for the Tower strut plate to stiffener, weld No.ND1-STSA3-1-89M-1-39. The welder is identified as #056364. ZPMC QC is identified as Mr. Chen Xi. The welding variables recorded by QC appear to comply with WPS-B-T-2112.

FCAW in the 3G position doing buttering on Tower inner connecting plate edge area on north tower lift 2 & 3 . The piece number is identified as SPSA3-70. The welder is identified as #066912. ZPMC QC is identified as Mr. Chen Xi. The welding variables recorded by QC appear to comply with WPS-345-FCAW-3G(3F)-REPAIR. The weld repair report is recorded as WR-T-WR2961.

Bay #11

This QA Inspector observed the following work in progress:

SMAW in the 1G position for the Tower strut plate to stiffener, weld No.ESD1-TL5-B/F-37B. The welder is identified as #058009. ZPMC QC is identified as Mr.Liu dao Feng . The welding variables recorded by QC appear

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to comply with WPS-B-T-3211-B-U4b.

SMAW in the 2F position for the Tower strut plate to stiffener, weld No.WD1-STSA3-2-99M-1-64A/B. The welder is identified as #049099. ZPMC QC is identified as Mrs.Yu Dong Ping. The welding variables recorded by QC appear to comply with WPS-485-SMAW-2G(2F)-FCM-REPAIR-1.The repair welding report is CWR-T-CWR515.

SMAW in the 4G position for the Tower strut plate to stiffener, weld No.WSTL4-2B/L-61A/B. The welder is identified as #202323. ZPMC QC is identified as Mr.Xu jin Long. The welding variables recorded by QC appear to comply with WPS-485-SMAW-4G(4F)-FCM-REPAIR-1.The repair welding report is CWR-T-CWR515.

Ultrasonic Testing (UT)

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as Tower Strut T- joint.

The Weld Designation is as follows

ED1-A6003-7-007A /B
ED1-A6003-7-008A /B
ED1-A6003-7-009A /B
ED1-A6003-7-010A /B
ED1-A6003-7-011A /B
ED1-A6003-7-012A /B

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as OBG U-rib Connection plate corner- joint.

The Weld Designation is as follows

USPL1-237-001 and 002
USPL1-238-001 and 002
USPL1-239-001 and 002
USPL1-240-001 and 002
USPL1-241-001 and 002
USPL1-242-001 and 002
USPL1-243-001 and 002
USPL1-244-001 and 002
USPL1-245-001 and 002
USPL1-246-001 and 002
USPL1-247-001 and 002
USPL1-248-001 and 002

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USPL1-249-001 and 002
USPL1-250-001 and 002
USPL1-251-001 and 002
USPL1-252-001 and 002
USPL1-253-001 and 002
USPL1-254-001 and 002
USPL1-255-001 and 002
USPL1-256-001 and 002
USPL1-257-001 and 002
USPL1-258-001 and 002
USPL1-259-001 and 002
USPL1-260-001 and 002

During the Quality Assurance (QA) random in-process visual inspection at inside of West tower lift four Double Diaphragm 135M top side, this QA inspector discovered Base metal repairs being performed in way of temporary attachment removal areas on the top of the double diaphragm skin without the prior approval of the engineer. The material is A709M Grade 345 non SPCM. The West tower lift 4 at Bay 11.

This QA Inspector generated an incident report for this date.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Bera,Subhasis	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
